

Date: Monday, 18/08/2008 3:39:00 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BO 105 SKIDTUBE ASSEMBLY
<b>Job Number</b> : 41330	
<b>Estimate Number</b> : 10119	
<b>P.O. Number</b> :	<b>Part Number</b> : D105674011
<b>This Issue</b> : 18/08/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2966 REV A2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : A2
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/09/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.8.18</u>	
<b>Comment</b> : Est Rev:A 04.07.07 New Issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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JLD 08.9.16

**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP d105-674-0116 CHG002

2.0	D2962125	Outer Tube Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-125 Extrusion 17532

RT 08-08-26

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Open holes to Ø5/16" (0.313"). Deburr holes.

RT 08-08-26

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------

**Comment:** BENDING MACHINE

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Use 5/16" locator pin on buggy "A".

RT 08-08-27

5.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185-1G

RT 08-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Black

Job Number: 41330

Part Number: D105674011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut Aft end at 107.06" using DT8185D

3-Debur ends

4-Drill Aft Cap holes using DT8678

5-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.

6-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.

7-Open Aft Cap holes using #6 drill

8-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.

9-Debur holes.

10-Open remaining (16) crossbolt holes to Ø0.500

ET  
08-08-29

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2964

Cap

14101

A/R

Aluminum Rod

m108708/m107877

08-09-02

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole.

2-Grind Fwd Cap welds flush

ET 08-09-02

08-09-02

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/02 (10)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41330

Part Number: D105674011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

808/09/02

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8T 08-09-02

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 8-9-2

12.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to finish size as per Dwg D2966

2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966

8T 08-09-02

3-Deburr holes inside & outside, blow out chips

13.0

D2976

BO 105 Skidtube I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2976 Web

B-33545

AWM 8-9-2



14.0

D2971

Cross Bolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2971 Crossbolt Spacer

B-39011

BE 08/09/03

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41330

Part Number: D105674011

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2973

Cross Bolt Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)

Pick:

Qty Part Number Description Batch

7 D2973 Crossbolt Spacer

*214636 BE 08/09/03*

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expiry date :

*17108701*  
*8-10-01*

*- ANM 8-9-2*

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

*m108708 BE 08/09/03*

3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.

*BE 08/09/03*  
*- ANM 8-9-4*

4-Grind welds flush as per Dwg D2966

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*S 08/09/05*

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/09/05*

19.0

POWDER COATING

POWDER COATING



Comment: HAND FINISHING RESOURCE #1

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

*9:15am*

*jd*

*08.09.15*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41330

Part Number: D105674011

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:45 AM

JP

08/09/15 (XV)

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/09/15 (1)

21.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2965

Cap

B32009

FL

22.0

D29701

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2970-1

Wearplate

B3320

FL

23.0

D29703

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2970-3

Wearplate

B19590

FL

24.0

D31761

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3176-1

Bushing

B33222

FL

25.0

D31763

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3176-3

Nut

B37585

FL 08/09/15 (1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41330

Part Number: D105674011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

ALS71032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

36 ALS7-1032-130 Insert *m/05819*

or ALS4-1032-130

or AKS7-1032-130

or AKS4-1032-130



*F.L.*

27.0

AN960JD10L

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

*28* AN960JD10L Washer *m/05793*

*30*

*F.L.*

*(Pb) →*

28.0

MS27039108

Screw



Comment: Qty.: 26.0000 Each(s)/Unit Total: 26.0000 Each(s)

Pick:

Qty Part Number Description Batch

*26* MS27039-1-08 Screw *m/09061*

*F.L.*

*(Pb) →*

29.0

MS27039109

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-09 Screw *m/18057*

*F.L.*

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for foreign objects as per QS1 024

2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side.

Pick:

*F.L. 08/08/15*

*①*

# Dart Aerospace Ltd

W/O: 41330

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/9/17	# 27. 26	According to note 6 on sheet 1 of D2966 their should (screw) be a MS27032-1 and AN9605DD (washer) installed in this Location. change values of washer to 30 and AN9605DD MS27032-1 screws ESTIMATE #: 10119	E	08.09.22			S 8/9/17

Part No: D105-674-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41330

Part Number: D105674011

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description Batch  
A/R Sikaflex-291 M108443  
Sikaflex expiry date: 08/11

> F2 08/09/15 (1)

3-Wing Walk as per Dwg D2966 and QSI 005 4.4  
Batch: M108446

M-1 08/09/16 (1X)

31.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/09/18 (X)

32.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

\*\*\*\*\*ENSURE INSERTS ARE AT LOCATION (6) AS PER DWG D2966\*\*\*\*\*

S 08/09/18 (X)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

34.0

D2972

Bushing



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
6 D2972 Bushing 14103

SS 08/09/18 (X)

35.0

D2974

Packer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
1 D2974 Packer 31249

SS 08/09/18 (X)

36.0

D2975

Wearshoe



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
2 D2975 Wearplate 34234

SS 08/09/18 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41330

Part Number: D105674011

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

AN451A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 AN4-51A Bolt

M108376

JS 08/09/18 (X)

38.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10L Washer

M108376  
M105793

JS 08/09/18 (X)

39.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 MS21042L4

Nut

M107499

JS 08/09/18 (X)

40.0

MS27039108

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS27039-1-08 Screw

M109001

JS 08/09/18 (X)

41.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08.09.19 (1)

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D105-674-011G

Location:

Rev A

JS 08/09/18 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D105674011

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-22

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED  
00.05.11 [Signature]

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.4) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART  
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



# 01.01.24  
CP 01.01.30

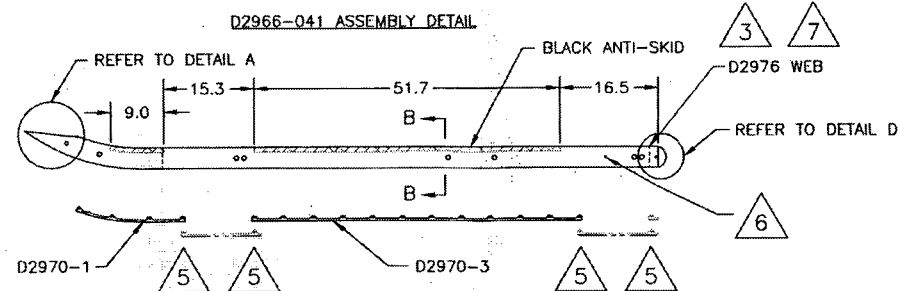
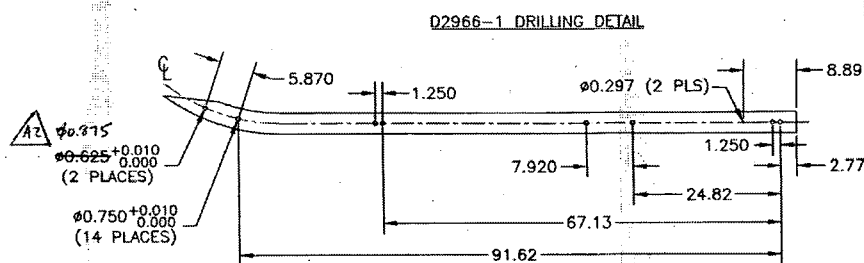
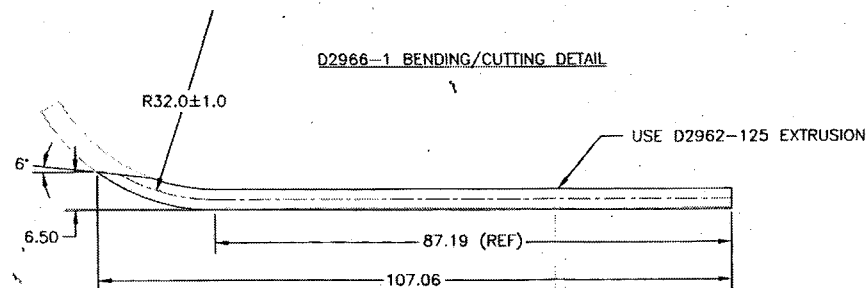
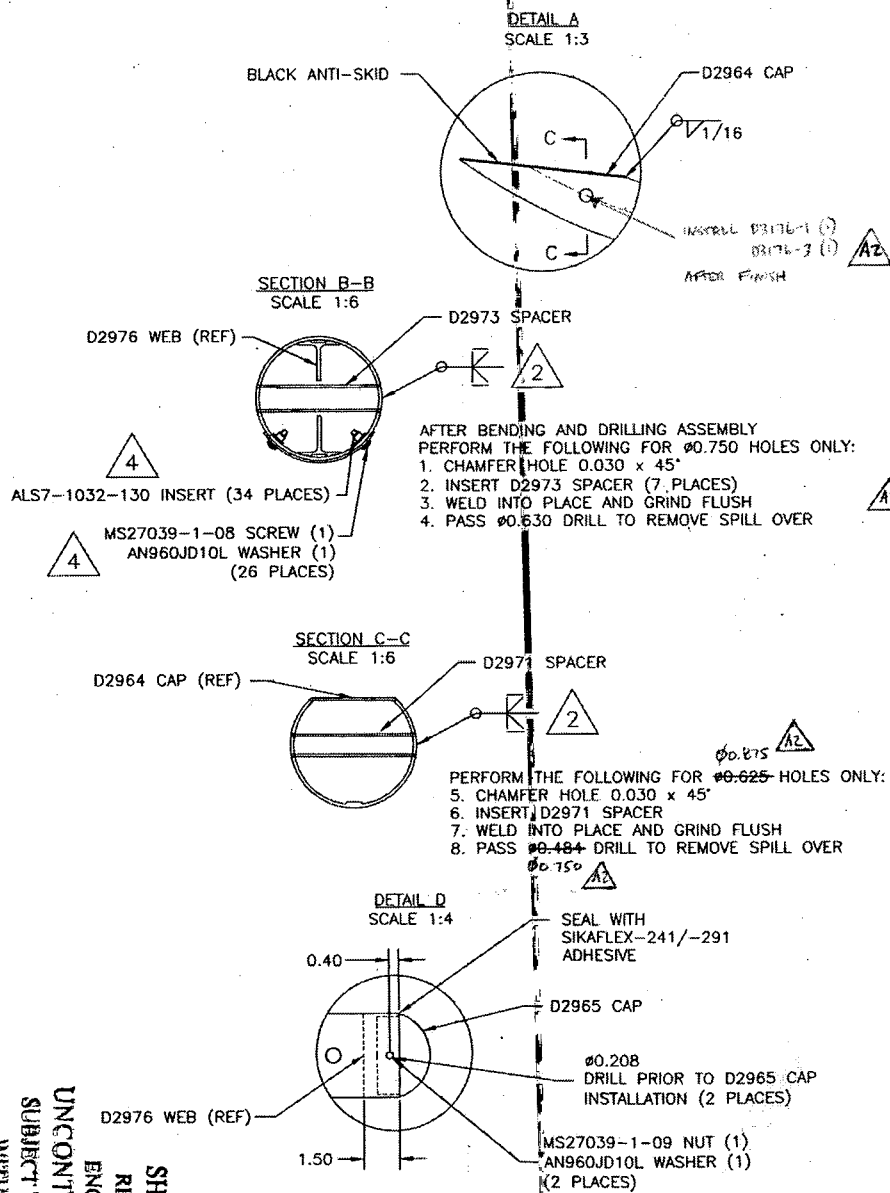
A2	02.10.30	ADD D3176-1/-3	[Signature]
A1	01.01.24	CHANGE COLOR TO BLACK SANDTEX	[Signature]

SHOP COPY  
RETURN TO  
ENGINEERING

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WORK ORDER  
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	CHECKED	RF	DART AEROSPACE USA, INC.	SHEET 2 OF 2
	DATE	00.03.08	TITLE	SCALE
			BO 105 SKIDTUBE ASSEMBLY	1:20

RELEASED  
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WPK-94268

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AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 41331  
Part number: D105 674 011  
Description: B0105 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Ed Dwyer Date of Test Coupon 08-09-05

Welder Barclay Elliot Date of Test Coupon 08-09-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld